

88 08/08/28

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BACK LEG		
Job Number	: 40989 -2			Part Number	: D37721		
Estimate Number	: 13378			Drawing Number	: D3772 REVA		
P.O. Number	:			Project Number	: N/A		
This Issue	: 05/08/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: 11 Type : SMALL /MED FAB			Due Date	: 21/08/2008		
Previous Run	: 40317			Qty:	26 Um: Each		
Written By	:			9			
Checked & Approved By	: JUD 08-8-05			split 31			
Comment	: Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR1250W125	304 RD Tube 1.250 x .125w
		
Comment: Qty.: 2.3100 f(s)/Unit Total : 83.1600 f(s) 304 RD Tube 1.250 x .125w BATCH: M108432		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to lenght as per dwg D3772 2-drill holes thru on both ends of tube as per dwg D3772 3- deburr 4-bend tube as per dwg D3772		
3.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		

SAB 08/08/13

J.F. 08/08/26

D.J. 08/08/26

FF 08/08/26

4.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location GA		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3772-1 PAR #: 11a Fault Category: Prod / Fab Ass material NCR: Yes No DQA: Date: 06/08/26
QA: N/C Closed: Date: 06/08/26

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/25	22	During drilling inspection holes are off center. They do not allow bolts to pass through. Harsh. Other (X4) R.C. holes were drilled off. Wrong location (not on the C/L) when tube was rotated. Set up error.	J Rasmyz	Scrap and Destroy and no replace Qty 4 BT	PT 06/08/26	S 06/08/26	J Rasmyz	S 06/08/25
			J Rasmyz	- Parts to be machined on Mass.	PT 06/08/26	J Rasmyz	J Rasmyz	S 06/08/26

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK LEG

Job Number: 40989

Part Number: D37721

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0.

QC21

FINAL INSPECTION/W/O RELEASE



08/08/27 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

8 7 6 5 4 3 2 1

D

D

C

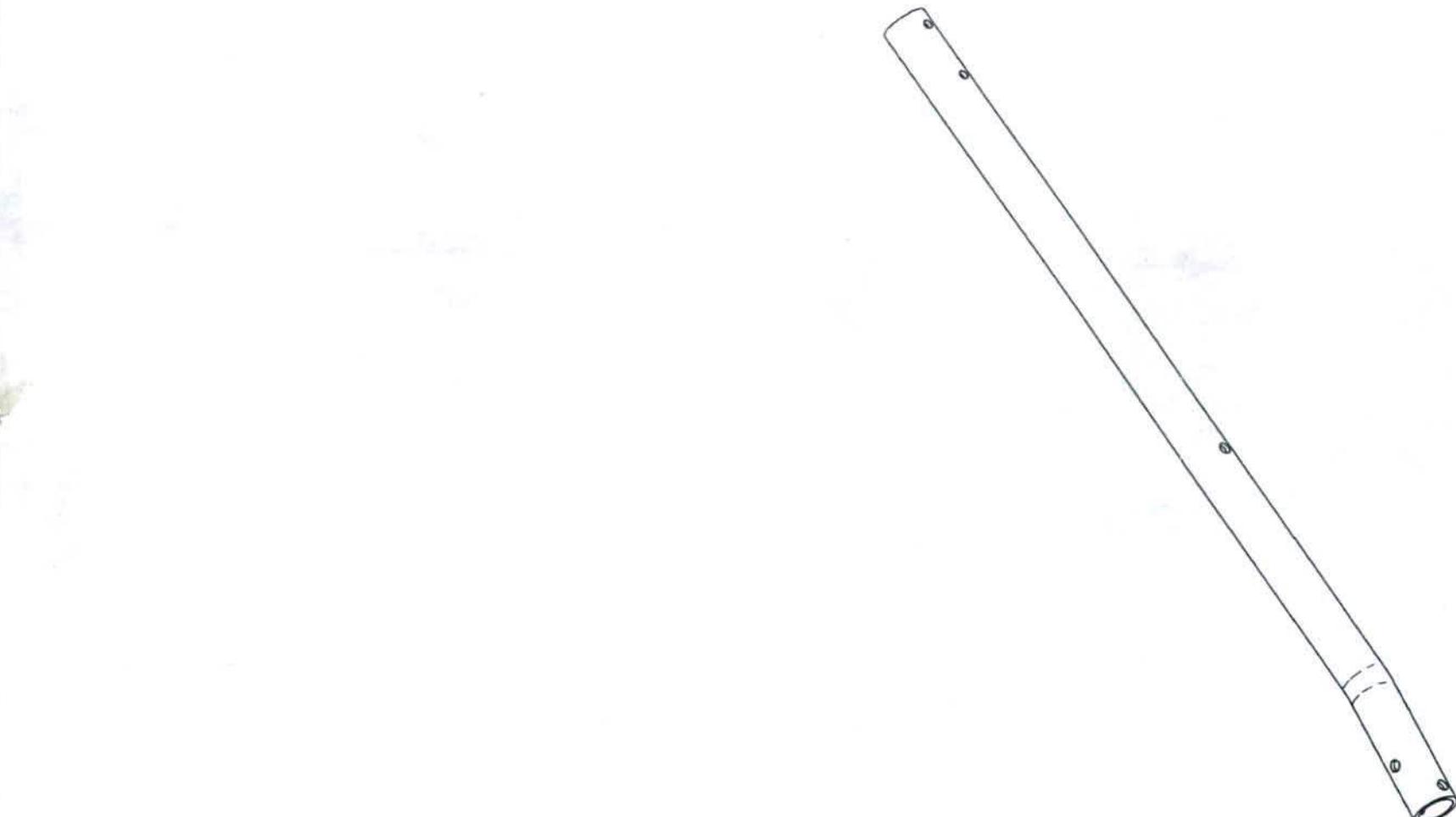
C

B

B

A

A



D3772-1 BACK LEG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1409189

RELEASED
08-06-13 MM

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.26 lbs

A	NEW ISSUE	HS	08.06.03
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>MM</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>MM</u>	D3772	SHEET 1 OF 2
APPROVED	<u>MM</u>	TITLE	SCALE
DE APPR.	<u>MM</u>	BACK LEG	NTS
DATE	08.06.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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